



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5571-1

Job Sheet 196786



Part No: D5571-1

Job Qty: 14 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5571 REV.B IPP REV:A 18.06.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	14 pcs		7/12/19	0.00	0.00	HAAS - 5		19-07-27
110	HAAS 5 Axis	14 pcs		7/12/19	0.50	38.46	HAAS - 5		19-08-01
120	QC 2	14 pcs		7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-08-01
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S202283



Part: D5571-1

Job No: 196786

Serial No/Batch: S200878

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 08/01/19

130 QC 8	14 pcs	7/12/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Δ.e 19-08-01
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	14 pcs	7/12/19	0.00 1.75	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ AUG 01 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 -	

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				B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	14 pcs	7/12/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	AB 19-8-2
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
152 Spray Paint - 2 - B4B	14 pcs	7/12/19	0.00 7.00	Spray Paint - 1 - B4B	AB 19-8-3
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
154 QC 14	14 pcs	7/12/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
160 Packaging 3-1 - Stock - B4B	14 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	TF
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	14 pcs	7/12/19	0.00	0.00	QC 21 - SA - 21	D&P 21 AUG 06 2019
					QC 21 - SA - 70	9-68
					QC 21 - SA - 53	
Part Op 110 - (HAAS CNC vertical machine #5), 1-Machine per folio FC101 DWG REV: B					FOLIO REV: 11	2-

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Descriptions: Deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

152 - PRIME ONLY IN AREA SHOWN (SADDLE-TO-SKIDTUBE BORE AND EDGE ALL AROUND) PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER BATCH: 5198114)

154 - (QC14- Inspect Spray Paint)

160 - (Identify as per dwg & Stock Location: LG001)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7050T7451P4.50X6.25X10.50	7050 Aluminum Plate, 4.5" Thick x 6.25" Wide x 10.50" Long	14 Ea (1 ea)	100-Machining - Issue SN	<u>5197876</u> <u>5197877</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Machining - Issue SN	M7050T7451P4.50X6.25X10.50	14	2	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 196 786
Description: Saddle		Part Number: DSS71-1
Inspection Dwg: DSS71 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.018	+/- .010	2.018	✓		SLIO	View
1.461	+/- .010	1.458	✓			
.763	+/- .005	.765	✓			
.273	+/- .010	.271	✓			
Ø.098	+ .004 / - .001	.102	✓			
.280	+/- .010	.280	✓			
.559	+/- .010	.560	✓			
1.968	+/- .010	1.966	✓			
1.421	+/- .010	1.420	✓			
.547	+/- .010	.546	✓			
.654	+/- .010	.653	✓			
.315	+/- .010	.312	✓			
.629	+/- .010	.628	✓			
6.115	+/- .010	6.119	✓			
1.767	+/- .010	1.765	✓		Height gauge	View
1.28	+/- .030	1.280	✓		SLIO	View
.467	+/- .010	.465	✓			
.485	+/- .010	.483	✓			
.992	+/- .005	.992	✓			
.992	+/- .005	.992	✓			
5.128	+/- .010	5.128	✓		Height gauge	
10.256	+/- .010	10.259	✓		"	
Ø.193	+ .005 / - .001	.195	✓		SLIO	View
.284	+/- .010	.285	✓			
.284	+/- .010	.285	✓			
.614	+/- .010	.615	✓			
2.407	+/- .010	2.412	✓			
.376	+/- .010	.376	✓			
1.181	+/- .010	1.180	✓			
.583	+/- .010	.583	✓			
Ø.386	+ .006 / - .001	.387	✓			
.602	+/- .010	.602	✓			

Measured by: 20 9-89	Checked by: B.E.	QC Inspector:
Date: 19-07-27	Date: 19-08-01	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 196 786
Description: Saddle		Part Number: DSS71-1
Inspection Dwg: DSS71 Rev: HB		Page 1 of 1

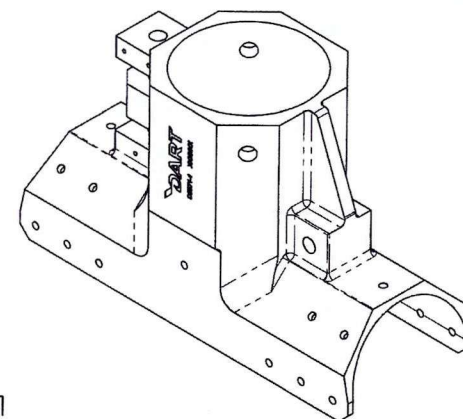
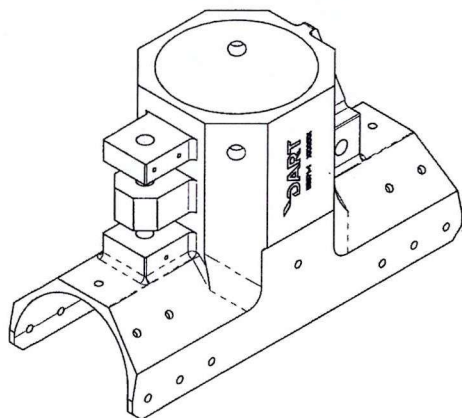
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.91	+/- .030	.920	✓		SL10	Vein
1.189	+/- .010	1.188	✓			
Ø 3.580	+/- .005	3.581	✓			
3.720	+/- .010	3.7217	✓			
.156	+/- .010	.157	✓			
Ø 2.795	+/- .010	2.795	✓			
Ø .189	+ .005/- .001	.190	✓			
2.952	+/- .010	2.954	✓			
.794	+/- .010	.793	✓			
1.004	+/- .005	1.004	✓			
3.425	+/- .005	3.425	✓			
Ø .193	+ .005/- .001	.195	✓			
4.035	+/- .010	4.038	✓			
.339	+/- .010	.339	✓			
1.338	+/- .010	1.335	✓			
3.358	+/- .010	3.362	✓			
.467	+/- .010	.466	✓			
.08	+/- .030	.083	✓			
3.866	+/- .010	3.865	✓			
Ø 3.559	+ .010/- .000	3.565	✓			
R.08	+/- .030	.090	✓			
4.035	+/- .010	4.035	✓			
.973	+/- .010	.975	✓			
Ø .397	+ .006/- .001	.398	✓			
1.339	+/- .010	1.338	✓			
.807	+/- .010	.805	✓			
.493	+/- .010	.494	✓			
Ø .193	+ .005/- .001	.194	✓			
1.58	+/- .030	1.590	✓			
.973	+/- .010	.973	✓			
.375	+/- .010	.375	✓			
.375	+/- .010	.375	✓			

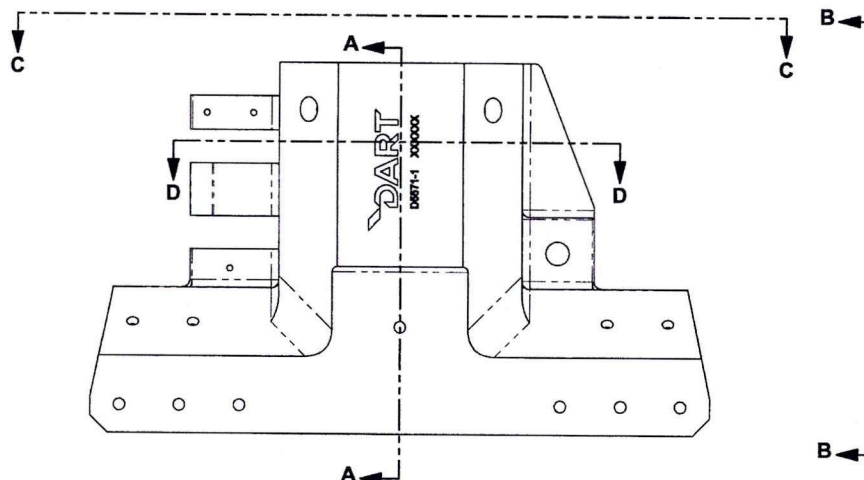
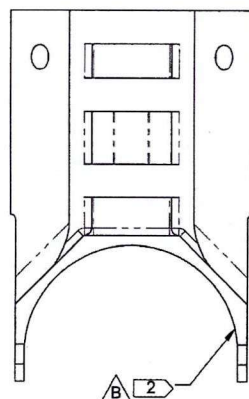
Measured by: 20 9-89	Checked by: D.A.	QC Inspector:
Date: 19-07-27	Date: 19-08-01	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196786 MWS
19-06-20



D5571-1 SADDLE (EC130)

NOTES:

- 1) MATERIAL: 7050-T7451 OR -T7651 ALUMINUM PLATE
PER AMS 4050 (T7451) OR
PER AMS 4201 (T7651)
REF DART SPEC M7050-T7451-P4.50X6.25X10.50 OR
REF DART SPEC M7050-T7651-P4.50X6.25X10.50
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME ONLY IN AREA SHOWN (SADDLE-TO-SKIDTUBE BORE) PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND S/N PER QSI 044 6.3
USE MAX DEPTH 0.010 WITH MIN TOOL RAD OF 0.010
ENGRAVE BOTH SIDES
- 7) WEIGHT: 3.76 lbs
- 8) ENGRAVE DART LOGO AS SHOWN USE MAX DEPTH OF 0.010
WITH A MIN TOOL RAD OF 0.010, ENGRAVE BOTH SIDES
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D5571-1-REVB.STP"

RELEASED

2019 JUN 19 ND
ECW19-625

APPROVED

B	PRIME ONLY IN AREA SHOWN WAS PRIME ALL OVER	ZF	19.01.02
A	NEW ISSUE	ZF	17.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	19.01.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5571
TITLE
SADDLE (EC130)
REV. B
SHEET 1 OF 4
SCALE
NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					